

CLAIMS:

1. A flocked transfer consisting essentially of a release sheet, a release agent on the release sheet, and flock on the release agent; the flock being formed in a desired pattern; the release agent holding the flock to the release sheet.

2. An article of manufacture including the transfer of Claim 1 wherein the transfer is adhered to a substrate.

3. The article of manufacture of Claim 2 wherein the transfer is adhered to the substrate using a thermosetting hot melt sheet.

4. The article of claim 3 wherein the thermosetting film is a thermosetting polyurethane film or a thermosetting polyester film.

5. A method of producing an article of manufacture having a flocked surface; the method comprising:

supplying a flocked release sheet comprising a release sheet with flock adhered thereto;

adhering a thermosetting hot melt film to the flock of the flocked release sheet; and

adhering the thermosetting hot melt film to a substrate to adhere the flock to the substrate.

6. The method of claim 5 wherein the step of adhering the thermosetting hot melt film to the flocked release sheet comprises heating the thermosetting hot melt film to a temperature at which the hot melt film becomes tacky, but below a temperature at which the hot melt film begins to cure and cross-link.

7. The method of claim 5 wherein the step of adhering the thermosetting hot melt film to the substrate comprises heating the hot melt film to a temperature at which the hot melt film cures and cross-links.

8. The method of Claim 7 wherein the hot melt film is heated to about 300°F.

9. The method of claim 5 wherein the step of adhering the thermosetting hot melt film to the flocked release sheet and the step of adhering the thermosetting hot melt film to the substrate are performed in a substantially simultaneously in a single operation.

10. The method of claim 5 wherein the method is continuous.

11. The method of claim 5 wherein the thermosetting film is a thermosetting polyurethane film or a thermosetting polyester film.

12. A method for continuously producing an article of manufacture having a flocked surface; the method comprising:

providing flocked release sheet consisting essentially of a release sheet with flock applied thereto;

providing a thermosetting hot melt film;

providing a substrate;

bringing the substrate, thermosetting hot melt film and flocked release sheet together with the hot melt film between the release sheet and the substrate and with the flock in contact with the thermosetting hot melt film, to produce a pre-assembly;

applying heat to the pre-assembly to adhere the flocking to the substrate; and

removing the release sheet from the flocking to produce a flocked substrate.

13. The method of claim 12 including a step of applying pressure to the pre-assembly.

14. The method of claim 12 wherein the step of applying heat comprises heating the pre-assembly to about 300°F.

15. The method of claim 12 wherein the thermosetting hot melt film is a thermosetting polyester or a thermosetting polyurethane.

16. The method of claim 12 including a step of cutting the flocked substrate to desired lengths to form articles.

17. The method of claim 12 including a step of collecting the flocked substrate on a product roll.

App A
App A'

